

Work Order ID 50747

July 21, 2009 12:43:57 PM

Page 1

Item ID: D2017-129

Accept

Revision ID: E

Item Name: Step Strut

Setup Start

Stop

Start Date: 7/06/09 Start Qty: 2.00

Required Date: 7/06/09 Req'd Qty: 2.00

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: *[Signature]*

Date: Tooling:

Date:

Run Start

QC: *[Signature]*

Date: SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2017

Rev F

100

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

90

[Handwritten mark]

Punch tube as per Dwg
+ Debur

110

White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME:

11:15 AM

FINISH TIME:

4:00 PM

120

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

2) 50747/10 (2)

*8B 09/09/09
M-L 09/09/10*

2) 11 09-09-14

2
(2X)

(X2)

(2)

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July 21, 2009 12:43:57 PM

Page 2

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Start Date: 7/06/09 Start Qty: 2.00

Required Date: 7/06/09 Req'd Qty: 2.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

Stop

QC:


Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location: 

0.00



Packaging

Memo

0.00

Packaging

9/9/11 (2x) SP

140

QC21- Final Inspection - Work Order Release

0.00

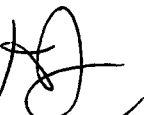


QC

Memo

0.00

Quality Control

09/09/15 
07-9-15

| Status | Item ID | Rev | Name | Start Date | Quantity | PeJOMp Date | Secrap ap | Quammeind | NEC IICX I | Sortme | Offselan | Ty1 | Per | Och to | lore Ce | Last | Idd Da |
|--------|------------------|-----|---------------------|------------|----------|-------------|-----------|-----------|------------|--------|----------|-----|-----|--------|---------|------|--------------|
| ✓ | M304TR0.750W.049 | | 304 RD Tube .750... | 6/24/09 | 2.6417 | f | 100 | 5 | 0.0... | | | | 1 | 0 | M... | | 6/3... 6/... |

Picklist Print

July 22, 2009 12:18:49 PM

Page 1

Work Order ID: 50747

Parent Item: D2017-129RevE

Parent Item Name: Step Strut

Comments:

Start Date: 7/06/09

Required Date: 7/06/09

Start Qty: 2.00

Required Qty: 2.00

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Remaining Qty To Pick | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|
| M304TR0.750W.049 | | Purchased | No | | | | f | 350.2300 | 5.2834 | | | |



304 RD Tube .750 x .049W



| <u>Warehouse</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|------------------|----------------|-----------------|
| <u>Location</u> | | |
| Main Warehouse | | |
| MAT | 350.2300026 | |
| 107518 | 7.27 | |
| 108498 | 0 | |
| 109314 | 8.5 | |
| 110113 | 0.73 | |
| 110271 | 0.03 | |
| 111096 | 9 | |
| 111457 | 11.43 | |
| 111619 | 13.2700026 | |
| 112187 | 300 | |

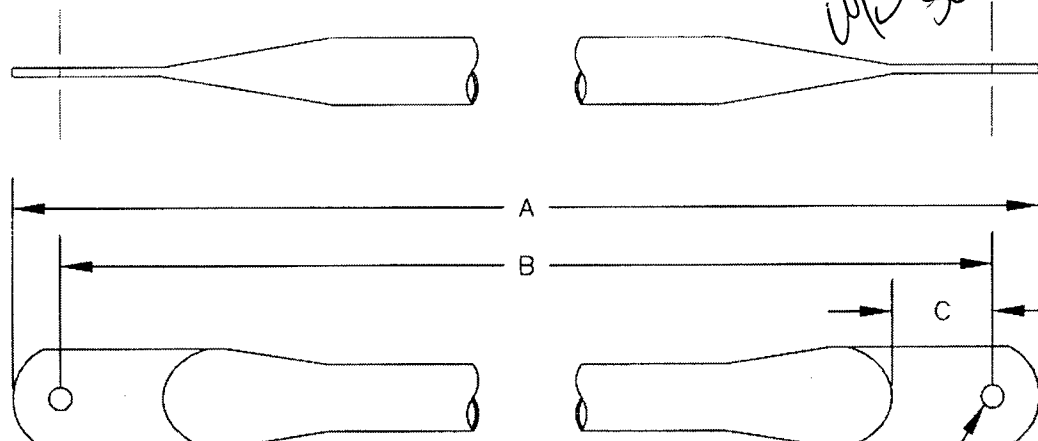
6 SB 09/0969

DART



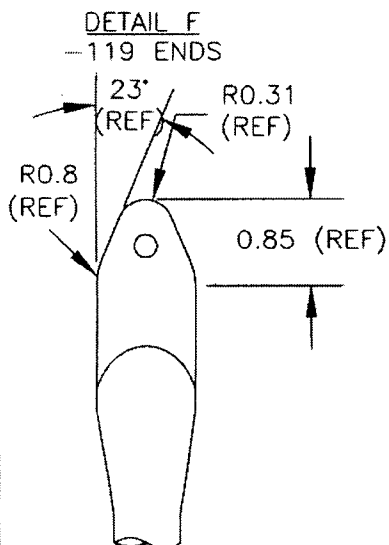
RELEASED

| DESIGN | DRAWN BY | DART AEROSPACE LTD |
|----------|-------------|--|
| BW | 11 | HAWKESBURY, ONTARIO, CANADA |
| CHECKED | APPROVED | DRAWING NO. |
| 4E | 11 | D2017 |
| DATE | TITLE | SHEET 1 OF 2 |
| 99.04.16 | STEP STRUTS | REV. E |
| C | 95.01.26 | ADDED PARTS |
| D | 96.03.28 | ADD PARTS |
| E | 99.04.16 | ENDS PUNCHED PER SPEC CTRL. -119 CHANGE (TSR A897) |
| | | SCALE |
| | | NTS |



PUNCH ENDS PER
SPEC CTRL D2638
(-119 SEE NOTE)

"D" DIA 0.25 TO BE PUNCHED (TYP. BOTH ENDS)
"E" DIA TO BE OPENED MANUALLY (ONE END ONLY)



| Part Number | A | B | C | D | E |
|-------------|-------|-------|------|-------|-------|
| D2017-101 | 17.73 | 16.93 | 1.30 | 0.250 | 0.312 |
| D2017-103 | 18.74 | 17.94 | 1.30 | 0.250 | 0.312 |
| D2017-105 | 14.95 | 14.15 | 1.30 | 0.250 | - |
| D2017-107 | 15.61 | 14.81 | 1.30 | 0.250 | - |
| D2017-109 | 13.93 | 13.13 | 1.30 | 0.250 | - |
| D2017-111 | 15.30 | 14.50 | 1.30 | 0.250 | - |
| D2017-113 | 20.50 | 19.70 | 1.30 | 0.250 | 0.312 |
| D2017-115 | 12.42 | 11.62 | 1.30 | 0.250 | - |
| D2017-117 | 13.86 | 13.06 | 1.30 | 0.250 | - |
| D2017-119 | 26.75 | 25.95 | 1.30 | 0.250 | - |
| D2017-121 | 12.30 | 11.50 | 1.30 | 0.250 | - |
| D2017-123 | 12.92 | 12.12 | 1.30 | 0.250 | - |
| D2017-125 | 19.55 | 18.75 | 1.30 | 0.250 | - |
| D2017-127 | 20.30 | 19.50 | 1.30 | 0.250 | - |
| D2017-129 | 31.43 | 30.63 | 1.30 | 0.250 | - |
| D2017-131 | 19.68 | 18.88 | 1.30 | 0.250 | - |
| D2017-133 | 30.66 | 29.86 | 1.13 | 0.250 | - |

NOTE:

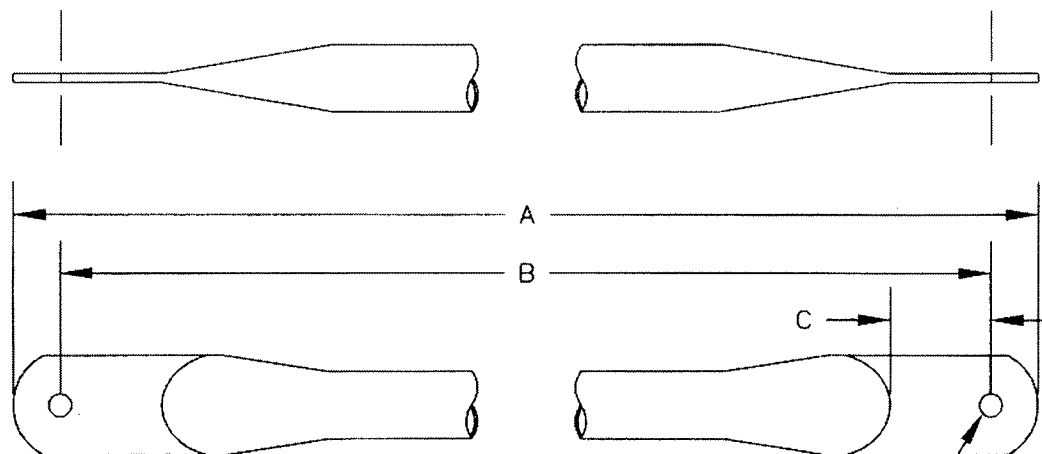
FOR D2017-119: PUNCH PER D2638, GRIND ENDS PER DT8360 (SEE DETAIL F FOR REF.)
BEND FLARED ENDS 8° UP/ 8° DOWN

MATERIAL: 304/316/318 SS, 0.75 OD x 0.049 WALL, ENSURE SEAMLESS TUBING IS USED
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DART



RELEASED
DATE: 04/01/11
BY: KE



"D" DIA 0.25 TO BE PUNCHED (TYP. BOTH ENDS)

| Part Number | A | B | C | D |
|-------------|-------|-------|------|-------|
| D2017-201 | 21.31 | 20.51 | 1.30 | 0.250 |
| D2017-203 | 16.39 | 15.59 | 1.30 | 0.250 |
| D2017-205 | 16.53 | 15.73 | 1.30 | 0.250 |
| D2017-207 | 13.85 | 13.05 | 1.30 | 0.250 |
| D2017-209 | 15.64 | 15.33 | 1.30 | 0.250 |
| D2017-211 | 15.67 | 14.87 | 1.30 | 0.250 |
| D2017-213 | 15.82 | 15.02 | 1.30 | 0.250 |
| D2017-215 | 16.47 | 15.67 | 1.30 | 0.250 |
| D2017-217 | 16.70 | 15.90 | 1.30 | 0.250 |
| D2017-219 | 13.65 | 12.85 | 1.30 | 0.250 |
| D2017-221 | 13.58 | 12.78 | 1.30 | 0.250 |
| D2017-223 | 12.95 | 12.15 | 1.30 | 0.250 |
| D2017-225 | 13.99 | 13.19 | 1.30 | 0.250 |
| D2017-227 | 30.67 | 29.87 | 1.30 | 0.250 |
| | | | | |
| | | | | |
| | | | | |

50747

NOTE:

MATERIAL: 304/316/318 SS, 0.75 OD x 0.049 WALL, ENSURE SEAMLESS TUBING IS USED
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

FINISH: POLISHED (435 L) PER DART QSI 018 (435 L)

| | | | | |
|---------|----------|-------------|-------------|---|
| DESIGN | BW | DRAWN BY | 1/1 | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA |
| CHECKED | KE | APPROVED | [Signature] | |
| DATE | 99.04.16 | DRAWING NO. | D2017 | REV. E |
| | | TITLE | STEP STRUTS | SHEET 2 OF 2 |
| | | SCALE | | NTS |